

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009636**Date Inspected:** 10-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Yu Dong Ping, Feng Guo.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

Bay 10 Shear Plate

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% and random Visual Testing (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT reports for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

NSD1-A112A/H-1A/B

This Quality Assurance (QA) Inspector observed the following work in progress:

Bay 11

FCAW welding of weld joint 8 located on WD1-A597B/C-7.

Welder is identified as 042218. ZPMC QC is identified as Mr. Xu Jin Long.

The welding variables recorded by QC appeared to comply with WPS-B-T-2333-Tc-P4-F.

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SMAW welding of weld joint 1A located on WD1-SA3-18-99M-8.

Welder is identified as 058009. ZPMC CWI is identified as Yu Dong Ping.

The welding variables recorded by QC appeared to comply with WPS-B-T-3211-Tc-U5b-1.

SMAW welding of weld joint 1A located on WD1-SA3-18-109M-7.

Welder is identified as 040656. ZPMC CWI is identified as Yu Dong Ping.

The welding variables recorded by QC appeared to comply with WPS-B-T-3211-Tc-U5b-1.

East Tower Lift 4 D/E Corner Seam

SMAW welding of weld joint 1A located on ESTL4-2L/L.

Welder is identified as 046704. ZPMC CWI is identified as Mr. Peng Guo.

The welding variables recorded by QC appeared to comply with WPS-B-T-3211-C-U2.

East Tower Lift 4 C/D Corner Seam

SMAW welding of weld joint 2A located on ESTL4-2L/L.

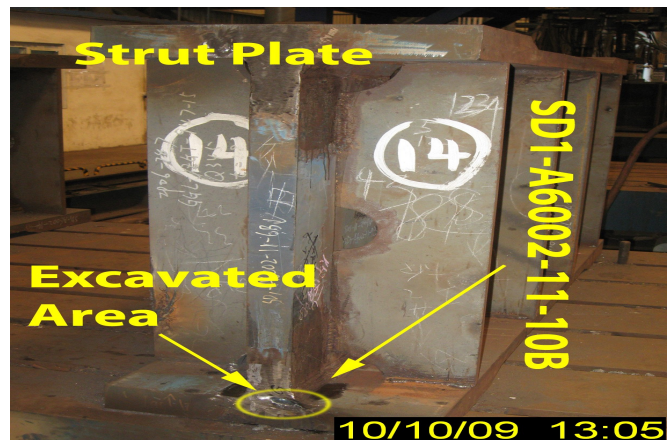
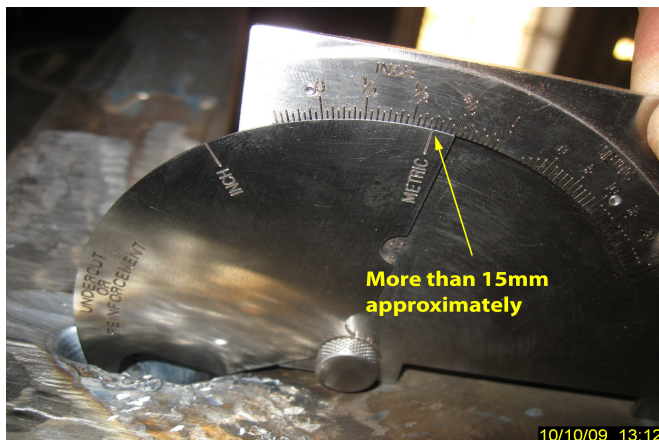
Welder is identified as 041271. ZPMC CWI is identified as Mr. Peng Guo.

The welding variables recorded by QC appeared to comply with WPS-B-T-3212-C-U2.

During random verification Visual Testing (VT) of Strut plate, located in the Tower bay 11, Caltrans Quality Assurance (QA) Inspector observed Fracture Critical Weld (FCW) SD1-A6002-11-10B was excavated at the edge by ZPMC personnel. The excavation was measured as being 35mm in length, 19mm in width and more than 15mm in depth approximately. This excavation had been carried out without any approval of engineer and without informing to ZPMC QC/CWI personnel. This issue has an incident report.

The attached photographs provide additional detail

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
